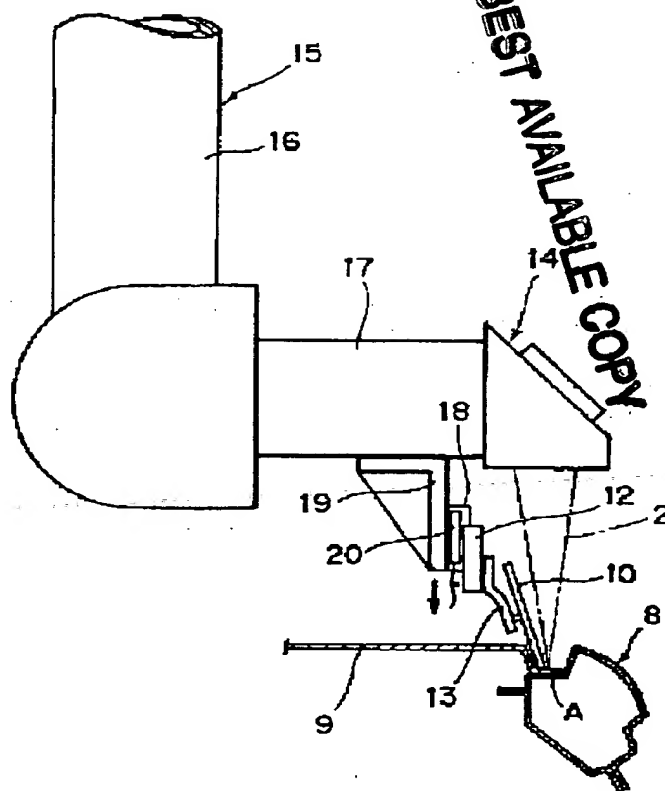


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TITLE : LASER WELDING METHOD



CONSTITUTION: Parts to be welded of works 8, 9 are pressed and restrained by a press roller 10 to give a constant pressing force by an air cylinder 18. The displacement in the vertical direction of the press roller 10 according to the shape variance of the works 8, 9 is detected by a position sensor 20, and the sensor output is feedback to the robot control system side to correct the relative position of a laser beam machining head 14 to the works 8, 9. The focal position A of the laser beam 2 is constantly placed on the surface of the parts to be welded irrespective of the shape variance of the works 8, 9.

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